Work Order ID 73896 LH

Friday, September 16, 2011 3:46:59 PM

Item ID: D206-642-151
Revision ID:
Item Name: Replacement Skidtube
Start Date: 9/16/2011 **Start Qty:** 1.00
Required Date: 10/21/2011 **Req'd Qty:** 1.00
Reference:

Left Hand

Accept **Setup Start** **Stop**

Cust Item ID:
Customer:

Approvals: **Process Plan:** MF **Date:** 11-09-19 **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D3804	A								
IIN-D206-642	O								
100		0.00							
DC	DOCUMENT CONTROL								
Document Control	**Memo**	0.00							
	Photocopy bluefile & type labels per PPP	D206-642-151	CHG001						

N/A

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 73896

Friday, September 16, 2011 3:46:59 PM

Item ID: D206-642-151 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Replacement Skidtube

Start Date: 9/16/2011 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 10/21/2011 **Req'd Qty:** 1.00 **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110		0.00							
Skidtubes	Skidtubes								
Skidtubes	**Memo**	0.00							

1-Deburr Fwd edge of tube

2- Remove ridge on inside of Fwd edge of tube as per Dwg D3804 > MOB 11-9-19

3-Weld Fwd Cap as per Dwg D3804. Use aluminum rod. Grind D2647 to fit as required.
Pick:
Qty ☐Part Number☐ Description☐Batch
A/R☐☐ Aluminum Rod☐ M112860 > BE 11/09/19

4-Grind weld flush to cap on top surface only. DP 11-9-20

5-Cut Aft end as per dwg D3804 from front of tube and Deburr MOB 11-9-22

6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D3804 BB 11/09/22

7-Open holes for Aft end cap as per Dwg D3804 with #30 Drill Bit using DT8025.

8-Drill pilot holes using Dt8166 & DT8169D & DT9771.

9-Locate DT8732 from inner Aft saddle hole & 3rd crossbolt hole. Insert D3286-1 doubler using DT8732 & D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732 & doubler leaving DT8732 for added support. DL 11/09/24

10- Drill D3286-1 doubler rivet holes in tube using # 30 drill, spot drilling doubler at the same time.

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Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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NOTE: Date & initial all entries

Item ID: D206-642-151 **Accept** **Setup Start**
Revision ID: **Stop**
Item Name: Replacement Skidtube
Start Date: 9/16/2011 **Start Qty:** 1.00 **Cust Item ID:**
Required Date: 10/21/2011 **Req'd Qty:** 1.00 **Customer:**
Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start**
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
	11-Working from the center out, drill # 30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads. 12-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D3804 13-Remove D3286-1 doubers, identify orientation, deburr, then attach them to the workorder								
	14-Remove indexing edge using DT8741 as per Dwg D3804 15-C'sink GHW rivet holes as per Dwg D3804 16- Open Aft cap hole #6. ****no wearplate holes for this skidtube**** 17-Deburr tube and blow out chips from inside the tube								
120 QC Quality Control	QC6- Inspect dimensions to drawing	0.00							
	Memo	0.00							

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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NOTE: Date & initial all entries

Work Order ID 73896

Friday, September 16, 2011 3:46:59 PM

Item ID: D206-642-151 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Replacement Skidtube

Start Date: 9/16/2011 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 10/21/2011 **Req'd Qty:** 1.00 **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1	0.00							
	Memo	0.00	DZ/DL 11/09/27					11/09/27	
150 QC Quality Control	QC3- Inspect Part Finish	0.00							
	Memo	0.00	DP					11-9-28	
160 Skidtubes Skidtubes	Skidtubes	0.00							
	Memo	0.00							
	1-Open holes to finished size as per Dwg D3804, (without cutting fluid)		DZ/DL 11/09/28						
	2-C'sink crossbolt spacer holes as per Dwg D3804(without cutting fluid)								
	3-Deburr and blow out all chips from inside the tube								

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

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Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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NOTE: Date & initial all entries

Work Order ID 73896

Friday, September 16, 2011 3:46:59 PM

Item ID: D206-642-151 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Replacement Skidtube

Start Date: 9/16/2011 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 10/21/2011 **Req'd Qty:** 1.00 **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC6- Inspect dimensions to drawing	0.00				11-9-28			
QC	**Memo**	0.00							
Quality Control									
180		0.00							
Skidtubes	Skidtubes								
Skidtubes	**Memo**	0.00							

1-Locate, install and rivet doublers as per Dwg D3804. Micro-shave rivets as required DK 11/09/28

2-Bond D2654-3 web in place as per QSI 015. Ensure holes line up.Allow 12 Hrs. cure time before cutting
Start Date:☐ 11/9/28 ☐Time:☐ 450 ☐
Finish Date:☐ _____ ☐Time:☐ _____

Pick:
Qty ☐Part Number☐Description☐Batch
A/R☐☐Sikaflex-291☐ 118393 ☐☐
Sikaflex expire date:☐ 12/04/05

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Item ID: D206-642-151
Revision ID:
Item Name: Replacement Skidtube
Start Date: 9/16/2011 **Start Qty:** 1.00
Required Date: 10/21/2011 **Req'd Qty:** 1.00
Reference:

Accept **Setup Start** **Stop**

Cust Item ID:
Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC5- Inspect part completeness to step on W/O	0.00			DP 11-9-29				
QC Quality Control	**Memo**	0.00							

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W/O:		WORK ORDER CHANGES					
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 73896

Friday, September 16, 2011 3:46:59 PM

Item ID: D206-642-151 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Replacement Skidtube

Start Date: 9/16/2011 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 10/21/2011 **Req'd Qty:** 1.00 **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Skidtubes	0.00							
Skidtubes									
Skidtubes	**Memo**	0.00							

1-remove alodine from around hole and prepare for welding DC/DL, 11/09/29. 11/09/29

2-Prep per QSI 005 and Insert D2649 crossbolt spacers. Weld as per QSI 004 and Dwg D3804. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.
Pick:
Qty☐Part Number☐Description☐Batch
A/R☐☐Aluminum Rod☐ 117884

3-Grind welds flush as per Dwg D3804. JB 11/09/29

4-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D3804. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required.
A/R☐SS Rod☐ None DC/PMB 11/09/30

5-Counterbore 5/16" x 0.750" deep except 7th hole from Aft end as per Dwg D3804. Deburr

DP/ 11-10-1

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W/O:		WORK ORDER CHANGES					
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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NOTE: Date & initial all entries

Work Order ID 73896

Friday, September 16, 2011 3:46:59 PM

Item ID: D206-642-151 **Accept** **Setup Start**

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Item Name: Replacement Skidtube

Start Date: 9/16/2011 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 10/21/2011 **Req'd Qty:** 1.00 **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210 HandFinish Hand Finishing	HandFinishing	0.00				(1)			BB 11/10/03
	Memo Install D2680-041 Nut Plate as per Dwg D3804	0.00							
220 QC Quality Control	QC10- Inspect visual per QSI004- ground welds	0.00							
	Memo QC 9 →	0.00							11.10.03
230 QC Quality Control	QC5- Inspect part completeness to step on W/O (check end cnb holes)	0.00							
	Memo	0.00				(2)			

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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NOTE: Date & initial all entries

Work Order ID 73896

Friday, September 16, 2011 3:46:59 PM

Item ID: D206-642-151 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Replacement Skidtube

Start Date: 9/16/2011 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 10/21/2011 **Req'd Qty:** 1.00 **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240 HandFinish Hand Finishing	Pressure Wash per QSI005 4.3	0.00				1	Ø	M-L	11/10/04
	Memo	0.00							
250 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00				1	Ø	M-L	11/10/05
	Memo START TIME: 10:20 OVEN TEMPERATURE: 320 FINISH TIME: 10:50	0.00							
260 QC Quality Control	QC3- Inspect Part Finish	0.00				1	Ø	M	11/10/05
	Memo	0.00							

M118439

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
DATE	**STEP**	**Description of NC** Section A	**Initial** Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 73896

Friday, September 16, 2011 3:46:59 PM

Item ID: D206-642-151 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Replacement Skidtube

Start Date: 9/16/2011 **Start Qty:** 1.00

Required Date: 10/21/2011 **Req'd Qty:** 1.00

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270 HandFinish Hand Finishing	HandFinishing	0.00				1	0		MH 11/10/06
	Memo	0.00							
	1-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D3804. Clean excess adhesive.								
280 HandFinish Hand Finishing	HandFinishing	0.00				1	0		MH 11/10/06
	Memo	0.00							
	1-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive A/R☐☐Sikaflex-291☐ M111839☐3 Sikaflex expire date:☐ 12/05								
	2- Install wearplate as per dwg								
	2-Wing Walk as per Dwg D3804 and QSI 005 4.4☐ Batch: M111839 13								

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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NOTE: Date & initial all entries

Work Order ID 73896

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Revision ID:
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Start Date: 9/16/2011 **Start Qty:** 1.00
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Reference:

Accept
Setup Start
Stop
Cust Item ID:
Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
290 QC Quality Control	QC3- Inspect Part Finish	0.00							
	Memo	0.00							
300 QC Quality Control	QC5- Inspect part completeness to step on W/O	0.00							
	Memo	0.00							
310 Packaging Packaging	Packaging	0.00							
	Memo	0.00							

Identify and pack for shipping as per PPP D206-642-151
Location: _____
PPP Rev: PPP 7406

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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Accept
Setup Start
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Cust Item ID:
Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
320	QC21- Final Inspection - Work Order Release	0.00							
QC									
Quality Control	**Memo**	0.00							

11/10/20

MF 11-10-19

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

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NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Picklist Print

Friday, September 16, 2011 3:46:56 PM

Work Order ID: 73896

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 9/16/2011 **Required Date:** 10/21/2011

Start Qty: 1.00 **Required Qty:** 1.00

Comments: IPP REV:A 10.12.08 PER IIN REV.N DD VERF:EC IPP
REV:B 11.09.16 PER IIN REV.O DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2620 Skidtube, 206 Skidtube		Manufactured	No			110	Each	12.0000	1	1			
				Location		**Loc Qty**		**Loc Code**					
				LG	73781	12				1	MD/DP	11-9-19	
					68136	1							
					71616	5							
					71617	6							
D2647 Cap		Manufactured	No			110	Each	44.0000	1	1			
				Location		**Loc Qty**		**Loc Code**					
				LG002		44							
					55352	14				1			
					71171	30							
CR3212-4-04 Cherry Rivet		Purchased	No			180	Each	1,655.000	52	52			
				Location		**Loc Qty**		**Loc Code**					
				ST311		1655							
					116471	78							
					117816	477							
					118686	100							
					118840	1000				58			

DK 11/09/20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID: 73896

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 9/16/2011 **Required Date:** 10/21/2011

Start Qty: 1.00 **Required Qty:** 1.00

D2654-1 Web	Manufactured	No		180	Each	6.0000	1	1

Location	Loc Qty	Loc Code
LG	6	
64562	6	

D3286-1 Doubler	Manufactured	No		180	Each	32.0000	2	2

Location	Loc Qty	Loc Code
LG002	32	
52844	11	
64563	21	

D2649 Cross Bolt Spacer	Manufactured	No		200	Each	289.0000	19	19

Location	Loc Qty	Loc Code
LG	6	
68224	2	
71355	2	
72704	2	
LG001	283	
65317	1	
68507	11	
73390	271	

D3286-3 Spacer	Manufactured	No		200	Each	27.0000	2	2

Location	Loc Qty	Loc Code
LG002	27	
64564	27	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID: 73896

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 9/16/2011 **Required Date:** 10/21/2011

Start Qty: 1.00 **Required Qty:** 1.00

D2680-041 Nut Plate	Manufactured	No	210	Each	19.0000	1	1	(1)	BB 11/10/03

Location	Loc Qty	Loc Code
ST020	19	
55366	17	
70088	2	

CR3212-4-03 Cherry Rivet	Purchased	No	210	Each	1,138.000	2	2	(2)	BB 11/10/03

Location	Loc Qty	Loc Code
FP-B	2	
110139	2	
ST311	1136	
114859	1136	

AN960JD416 NAS1149D0463J Washer	Purchased	No	210	Each	0.0000	1	1	(x1)	M 11/10/03

M 118384

CCR264SS3-3 Cherry Rivet	Purchased	No	210	Each	435.0000	2	2	(2)	BB 11/10/03

Location	Loc Qty	Loc Code
FP-B	2	
113973	2	
ST311	433	
117086	23	
117849	410	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID: 73896

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 9/16/2011 **Required Date:** 10/21/2011

Start Qty: 1.00 **Required Qty:** 1.00

MS27039-4-06	Purchased	No	210	Each	29.0000	1	1	
Screw								

Location	Loc Qty	Loc Code	
FP-A	8		
115460	8		x1
ST292	21		
115460	21		

D2651-1	Manufactured	No	270	Each	289.0000	6	6	
Plug								

Location	Loc Qty	Loc Code	
fpa	109		
69018	109		x6
FP-A	180		
57869	1		
66445	10		
67760	36		
70691	100		
70839	2		
71037	31		

D2651-3	Manufactured	No	270	Each	799.0000	6	6	
O-Ring								

Location	Loc Qty	Loc Code	
FP-A	799		
61962	12		
66956	282		x6
73489	505		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID: 73896

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 9/16/2011 **Required Date:** 10/21/2011

Start Qty: 1.00 **Required Qty:** 1.00

D3873-1 Bushing	Manufactured	No	280	Each	160.0000	14	14	MH 11/10/06

Location	Loc Qty	Loc Code	
ST084	4	B73399	x3
68247	4		
ST088	156		
64760	1		
~~70690~~	54		x9
71837	101		

D2646 Aft Cap	Manufactured	No	280	Each	89.0000	1	1	MH 11/10/06

Location	Loc Qty	Loc Code	
FP004	45		
68280	45		
FP006	5		
62678	5		
FP-4	35		
70945	1		
~~71070~~	34		x1
fp5	4		
71038	4		

D3805-041 Wearplate Assembly Fwd, Low Gear	Manufactured	No	280	Each	0.0000	1	1	(x1) MH 11/10/06
				B73370				

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID: 73896

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 9/16/2011 **Required Date:** 10/21/2011

Start Qty: 1.00 **Required Qty:** 1.00

MS27039-1-08	Purchased	No		280	Each	1,296.000	2	2	
Screw									HH 11/10/06

Location	Loc Qty	Loc Code	
ST291	1296		
115108	96		
117423	300		
118378	400		x2
118910	500		

MS21042L3	Purchased	No		280	Each	2,603.000	7	7	
Nut									HH 11/10/06

Location	Loc Qty	Loc Code	
ST300	2603		
117441	24		
117601	374		
117885	205		
118451	1000		x1
118927	1000		

D3805-045	Manufactured	No		280	Each	6.0000	1	1	
Wearplate Assembly Aft, Low Gear									(x1) HH 11/10/06

~~A117~~ B73771

Location	Loc Qty	Loc Code	
FP	6		
70878	6		

AN960JD10L NAS1149D0332J	Purchased	No		280	Each	0.0000	2	2	
Washer									(x2) HH 11/10/06

A117087

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

Friday, September 16, 2011 3:46:57 PM

Work Order ID: 73896

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 9/16/2011 **Required Date:** 10/21/2011

Start Qty: 1.00 **Required Qty:** 1.00

AN3-37A	Purchased	No		280	Each	261.0000	7	7

Bolt

Location	Loc Qty	Loc Code	
ST353	211		
111668	111		X7
118628	100		
ST354	50		
117619	50		

NAS1149D0363J	Purchased	No		280	Each	2,623.000	7	7

Washer

Location	Loc Qty	Loc Code	
ST298	2623		
117601	308		
118077	1315		X7
118612	1000		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

ITEM	Qty -041	Qty -043	Part Number	Description
1	X		D3804-041	SKIDTUBE ASSEMBLY, 206 A/B LOW
2		X	D3804-043	SKIDTUBE ASSEMBLY, 206 A/B HIGH
5	1	1	D2600-1-160	EXTRUSION
6	1	1	D2646	AFT CAP
7	1	1	D2647	CAP
8	19	20	D2649	CROSS BOLT SPACER
9	6	8	D2651-1	PLUG
10	6	8	D2651-3	O-RING
11		1	D2654-3	WEB
12	1		D2654-1	WEB
13	1	1	D2680-041	NUT PLATE
14	2	2	D3286-1	DOUBLER
15	2	2	D3286-3	STUD
21	2	2	AN960JD10L	WASHER
22	1	1	AN960JD416	WASHER
23	2	2	CCR264SS3-3	RIVET
24	2	2	CR3212-4-03	RIVET
25	52	52	CR3212-4-04	RIVET
26	2	2	MS27039-1-08	SCREW
27	1	1	MS27039-4-06	SCREW

NOTES

1) MATERIAL: N/A
2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
   -POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
3) BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
7) IDENTIFICATION: NONE
8) WEIGHT: 12.5 lb
9) WELD PER DART QSI 004
10) BENDING: DAMAGE TOLERANCE ON FWD BEND:
    THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
11) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
12) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)

73896

RELEASED
09.03.03
per ECN 09-538

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	MB	08.07.07

DESIGN		DART AEROSPACE USA, INC
DRAWN		PORT HADLOCK, WA
CHECKED		DRAWING NO. D3804 — REV. A
MFG. APPR.		SHEET 1 OF 5
APPROVED		TITLE: SKIDTUBE ASSEMBLY, 206A/B — SCALE: NTS
DE APPR.		
DATE	08.07.07	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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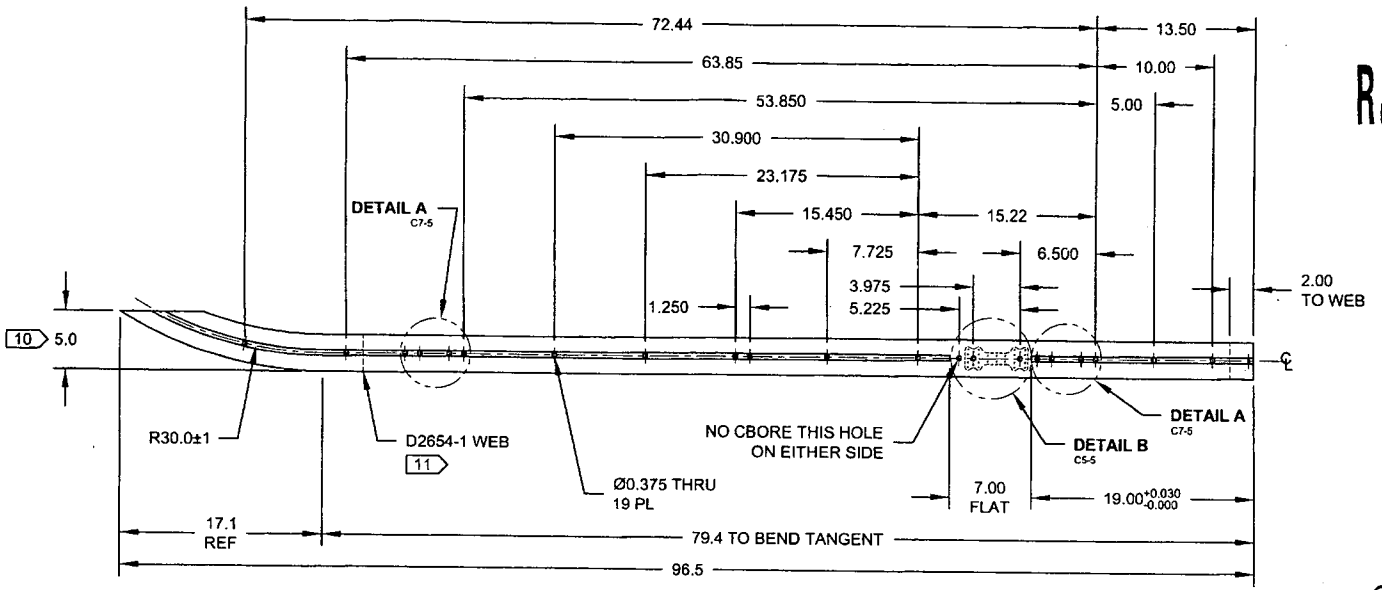
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

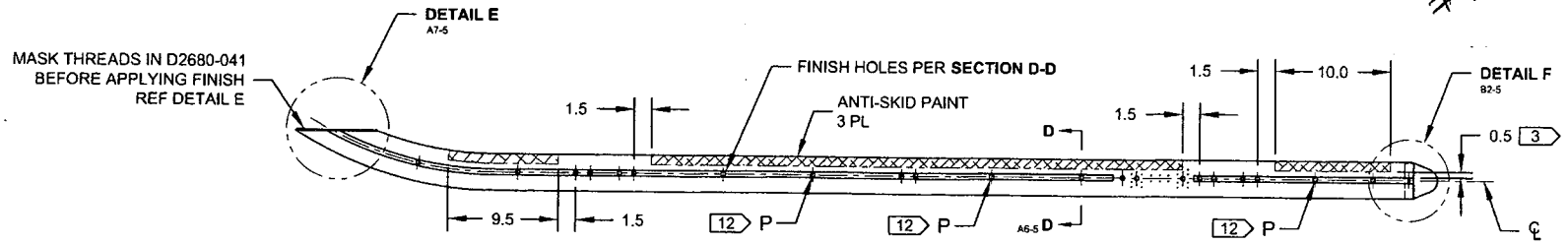
NOTE: Date & initial all entries

RELEASED
09.03.03



D3804-041 BENDING/DRILLING DETAIL

#73896



D3804-041 ASSEMBLY/FINISHING DETAIL

DESIGN		DART AEROSPACE USA, INC
DRAWN		PORT HADLOCK, WA
CHECKED		DRAWING NO. REV. A
MFG. APPR.		D3804 SHEET 2 OF 5
APPROVED		TITLE SCALE
DE APPR.		SKIDTUBE ASSEMBLY, 206A/B NTS
DATE 08.07.07		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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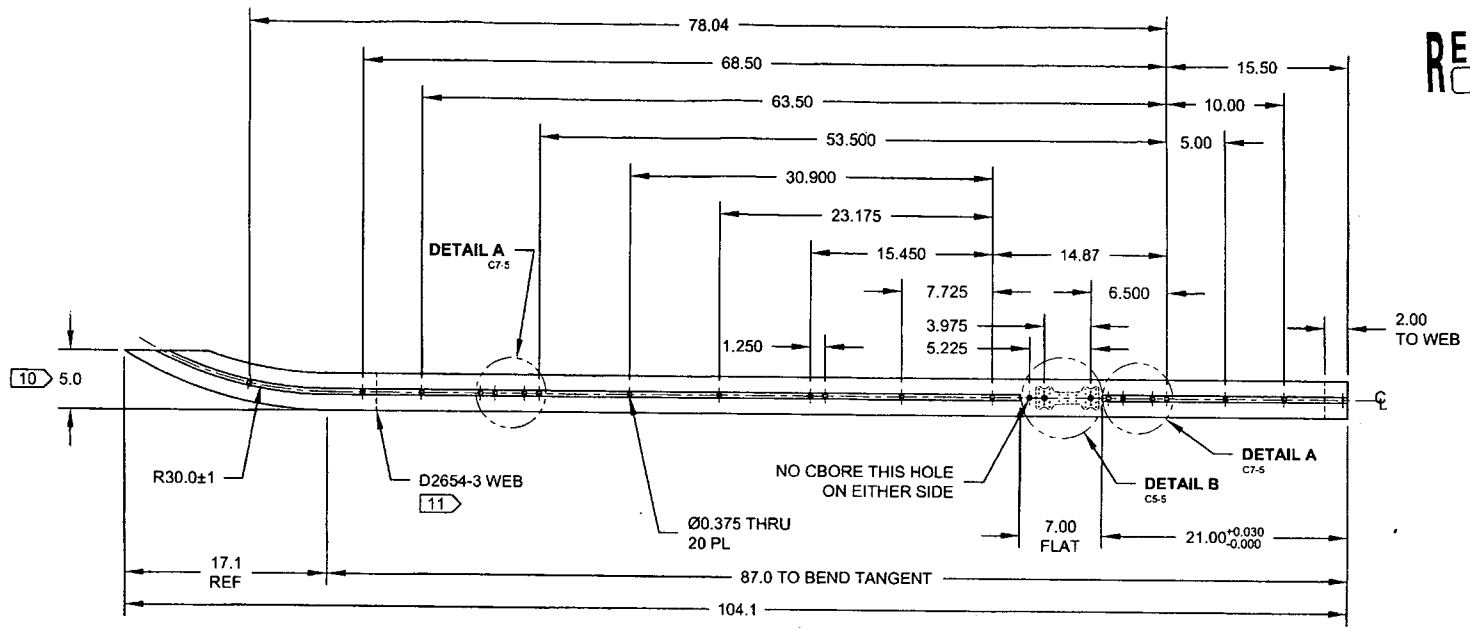
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

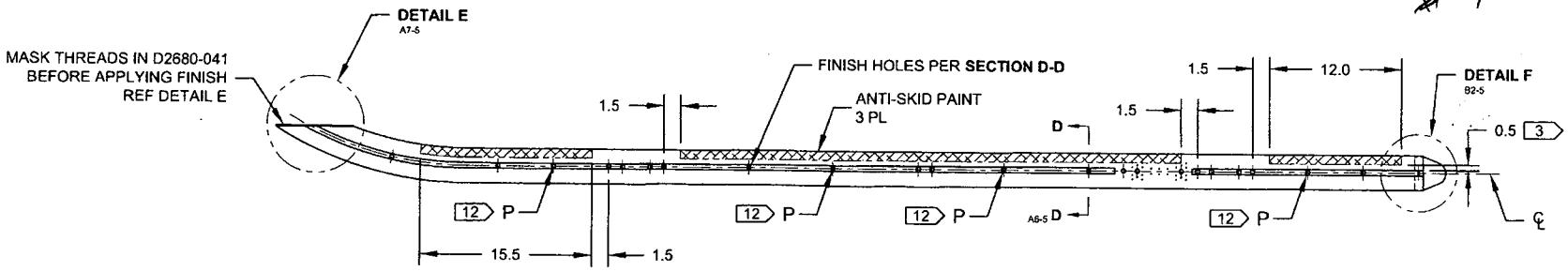
NOTE: Date & initial all entries

RELEASED
09.03.03



D3804-043 BENDING/DRILLING DETAIL

73896



D3804-043 ASSEMBLY/FINISHING DETAIL

DESIGN		DART AEROSPACE USA, INC
DRAWN		PORT HADLOCK, WA
CHECKED		DRAWING NO. D3804 REV. A
MFG. APPR.		SHEET 3 OF 5
APPROVED		TITLE SCALE
DE APPR.		SKIDTUBE ASSEMBLY, 206A/B NTS
DATE 08.07.07		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

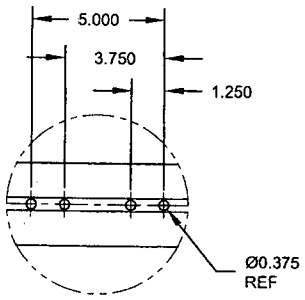
Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

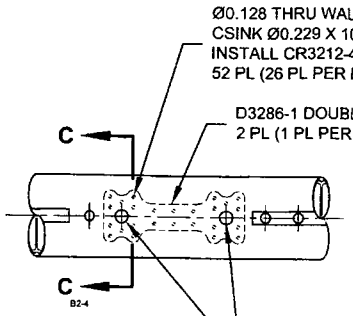
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

RELEASED
09.03.07

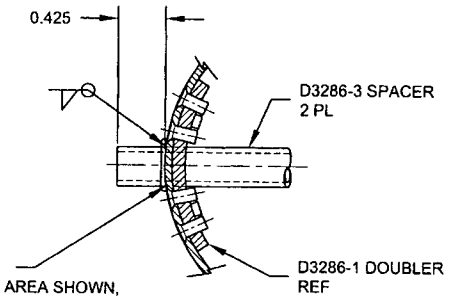


DETAIL A D6-2 C2-2 D6-3 C2-3
SCALE NONE



ENLARGE TO Ø0.500 IN D3286-1
ENLARGE TO Ø0.625 IN TUBE
4 PL (2 PL PER SIDE)

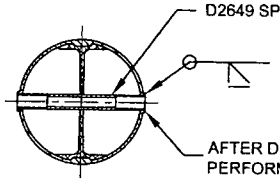
DETAIL B C3-2 C3-3
SCALE NONE



TO INSTALL D3286-1/-3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH OUTSIDE SURFACE OF ROUND TUBE
2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
3. ENLARGE HOLES IN D3286-1 TO Ø0.500
4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.03 X 45°
5. RIVET D3286-1 TO TUBE
6. INSERT D3286-3 SPACER
7. WELD IN PLACE AND GRIND FLUSH

SECTION C-C C6-4
PARTIAL SECTION
SCALE NONE

#7396



AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.03 X 45°
2. INSERT D2649 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. CBORE TO Ø0.313 X 0.75 DP (EXCEPT WHERE INDICATED)

SECTION D-D A4-2 A4-3
FOR Ø0.375 HOLES ONLY
SCALE NONE

DESIGN		**DART AEROSPACE USA, INC**	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3804	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SKIDTUBE ASSEMBLY, 206A/B	NTS
DATE	08.07.07		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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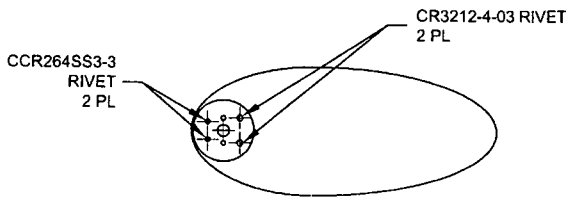
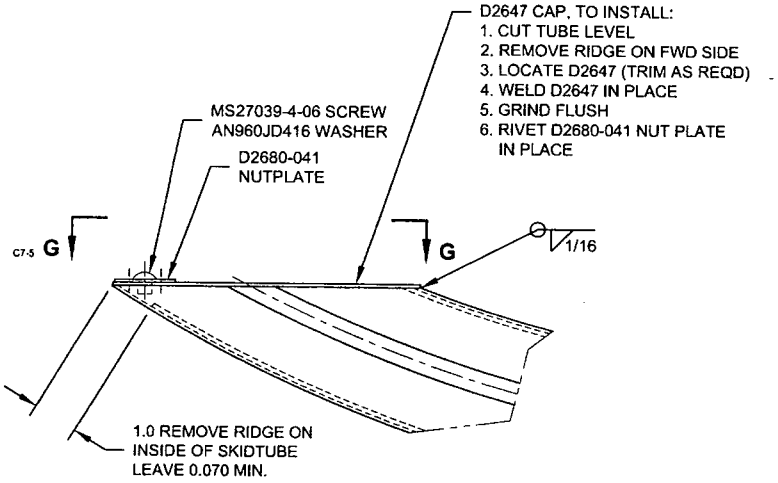
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

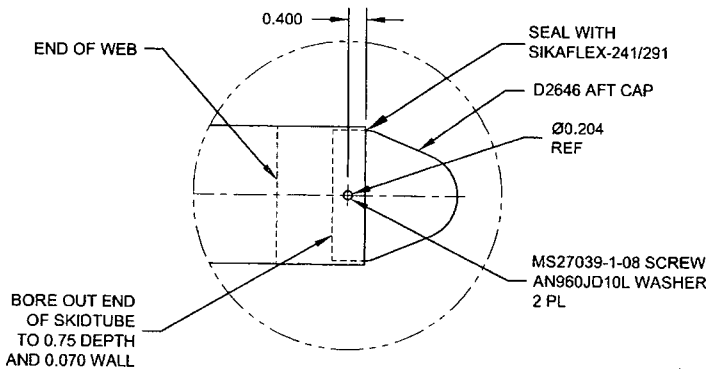
RELEASED
QP 09.03.07



VIEW G-G
SCALE NONE A7-5



DETAIL E
SCALE NONE B7-2 B7-3



DETAIL F
SCALE NONE B2-2 B2-3

#73896

DESIGN	QP	**DART AEROSPACE USA, INC**	
DRAWN		PORT HADLOCK, WA	
CHECKED	QP	DRAWING NO.	REV. A
MFG. APPR.		D3804	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SKIDTUBE ASSEMBLY, 206A/B	NTS
DATE	08.07.07		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

NO. 267

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Pat Ewers
Job number: 73212
Part number: A206-642-541
Description: Skid tube
Welding Process: Tig[✓] Mig[ ]
Base materiel: Aluminum
Current: AC[✓] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual:	pass[✓] fail[ ]
Penetration:	pass[✓] fail[ ]

UNACCEPTABLE

Cracks:	pass[✓] fail[ ]
Undercut:	pass[✓] fail[ ]
Pin holes:	pass[✓] fail[ ]
Overlap (cold lap)	pass[✓] fail[ ]
Porosity (surface):	pass[✓] fail[ ]
Coloration:	pass[✓] fail[ ]

Qualifier David Auvil **Date of Test Coupon** 11.09.26

Welder Pat Ewers **Date of Test Coupon** 11.09.26

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries